

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022909**Date Inspected:** 19-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr.Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

This QA Inspector randomly observed the following work in progress.

OBG 14EAST

SHIELDED METAL ARC WELDING PROCESS.

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 066733, 058087 and 068091 performing the Shielded Metal Arc Welding process on weld 001 located at PCMK SEG3019*. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2211-B-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067571, 066326 and 068917 performing the Shielded Metal Arc Welding process on weld 033 located at PCMK SEG3019*. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with

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WPS-B-P-2214-B-u2-Fcm-1.

FLUX CORED ARC WELDING PROCESS.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067079 performing the Flux Cored Arc Welding process on weld 001 located at PCMK X3703-001. ZPMC QC Mr. Zhu Yuan Yuan was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

WELD REPAIR

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066418 performing the Shielded Metal Arc Welding process on weld 168 located at PCMK SEG3019P. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-Fcm-Repair-1. Weld repair report identified as B-WR20247.

CRITICAL WELD REPAIR

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044779 performing the Shielded Metal Arc Welding process on weld 045 located at PCMK SEG3019BB. ZPMC QC Mr. Lv Li Qing was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Fcm-Repair-1. Critical weld repair report identified as B-CWR2917.

HEAT STRAIGHTENING

This Quality Assurance (QA) Inspector observed ZPMC personnel performing heat straightening, member identified as edge plate (EP3028A). Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Zhu Yuan Yuan was present to monitor the heat straightening process. The heat straightening appeared to comply with heat straightening Report HSR1 (B)-0462.

This QA Inspector observed ABF personnel performing Magnetic particle testing on the root pass of the deck panel splice weld. Weld number identified as SEG3019*-001

This QA Inspector observed erection/ installation of DP3165 and EP3028A was in progress in OBG 14 East.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer